

SPLIT

Dart Aerospace Ltd.

Date: Friday, 11/18/2005 3:03:36 PM
User: Linda Labelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 24843 -2
Estimate Number : 10313
P.O. Number : N/A
This Issue : 11/18/2005 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : PURCHASED PARTS
Previous Run : 23978
Written By : SEE COMMENT BELOW
Checked & Approved By : SEE ABOVE USER & DATE
Comments : Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF

Drawing Name : WEARPAD
Part Number : D26483
Drawing Number : D2648 REV D
Project Number : N/A
Drawing Revision : D
Material : N/A
Due Date : 12/20/2005 Qty: 400 Um: Each

Additional Product

Job Number



Seq. Machine Or Operation: Description:

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 146
Email or ship DXF file to vendor
Make per Drawing D2648-1
Material release note required

L

05.45.22

H/D

2.0 D26483F Wearpad



Comment: Qty: 1.0000 Each(s)/Unit Total: 400.0000 Each(s)
WEARPAD

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure material release note is attached

402

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

F 06.01.05

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary

N/A

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 24043

Part Number: D26483

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

- 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.
- 2-Identify as D2648-3

SP 06/04/10

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- Qty Description Batch
- A/R560Hardcoat M14442 M19612
- 1-Weld as per Dwg D2648 using Jig DT 8210
- 2-Remove any weld that penetrated through Wearpad if necessary

Ppl 06.02.09 (203)

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AA 06/02/09 (203)

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AA 06/02/09 (203)

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DL 06/03/24 (203)

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CL 06/03/24 (203)

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: FP 16

DL 06/03/24 (203)

13.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

203
SP 06/03/27

U 06.03.27

(13)



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 235 8069 / 235 3535 Wairuku
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: S21022495

CUSTOMER	Wilkinson	P50323 DI001	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC112397
CUSTOMER D/N	90-21N-686		PRODUCT	CRA WIDE COIL	PAGE	1 of 1
MILL Q/N	480737		DIMENSIONS	0.055" x 48" x Coil	DATE	09 June 2005

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)								
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100			x1000											x10000	x100	180°			GL, %	HRB	()	(feet)
R9-459713-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				54		1585
R9-459714-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				54		1457
R9-459715-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1					Good				48		1375
R9-459716-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1					Good				48		1473
R9-459717-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				48		1631
R9-459718-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				48		1093
R9-459719-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				50		1562
R9-459720-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				50		1535
R9-460380-00	641761	4	TR	20	13	17	12	18	25	5	8	1	1					Good				50		1581
R9-460381-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				49		1562
R9-460382-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				49		1503
R9-461458-00	642309	2	TR	18	10	20	11	17	19	1	6	1	1					Good				48		1785

PA: 227181
N: 55031MD009

7005

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	IMPACT TEST	CARBON EQUIVALENT VALUE (CE)
(F)=0.2% PROOF STRESS	(A)=200mm (C)=80mm (E)=2"	(A)=r0 (C)=r15	(A)=10mm x 10mm (B)=7.5mm x 10mm	(A)=C+Mn/8
(B)=LOWER YIELD STRESS	(B)=50mm (D)=5.65 x So (F)=9"	(B)=r0 (D)=r0+90+2r45 / 4	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	(B)=C+Mn/5+(Cr+V+Mo)/5+(Cu+Ni)/15
				(C)=C+Mn/8+Si/24 (D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Atish Misra
QC METALLURGIST

POB 146, 245, 267 1694 m

HD009-1 T M INDUSTRIAL (P50323DI001:641756)

3/3/2005 12:43 FAX 8042729137
 INTEGRIS METALS
 07/29/05 THU 16:55 FAX 804 272 9951
 INTEGRIS METALS
 3/3/2005 1:32 PAGE 001/004
 FAX 8042729137
 INTEGRIS METALS

0915

YEH MAU CORP.
 YEH MAU CORP.

INVOICE NO.:
 COMMODITY:

FORM 71
 PERRY COLD ROLLED STAINLESS STEEL SHEET AISI 304, 304 (SIC)
 FINISH WITH 100 MIC FILM ON MAIN SIDE, WITH BACK-PASS,
 SLITTED EDGE AISI 304, 2B FINISH WITH PAPER NOT RELEAVED,
 SLITTED EDGE,
 AISI 304

SPECIFICATION:
 CUSTOMER:

INTEGRIS METALS LTD

90250188 INSPECTION CERTIFICATE MATERIAL TEST/INSPECTION CERTIFICATES

工廠:高雄馬路竹脚頭安路365號
 345, SHUN AN RD., LU CHU HSIAO
 KAOHSIUNG TAIWAN R.O.C.
 TEL: (87) 8678005 FAX: (87) 8678008
 CERTIFICATE NO: 9008222
 DATE OF ISSUE: 05/19/2004

INTERNATIONAL METALS LTD																				
(ITEM NO) SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test CL=50 mm					Chemical Composition (%)									
		KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	EL (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100		
AISI 304 2B (7425-4228)																				
MGA48"x120" (7425-5851)	1	1,473	3,247	YU132553	34321644B-4	285	888	58	81	150	3.9	48	115	24	4	807	1827	3.2		
MGA48"x120" (7425-8310)	1	1,445	3,186	YU228940	34321939B-5	280	880	57	80	158	4.2	48	118	24	8	828	1828	2.8		
MGA48"x120" (7425-3849)	1	1,457	3,212	YU228245	35S22525A-3	285	836	64	82	160	4.6	48	126	30	3	818	1827	2.5		
MGA48"x120" (7425-3629)	1	1,435	3,164	YU131655	35S22522A-2	312	884	64	83	183	4.5	48	107	32	7	812	1834	2.2		
MGA48"x120" (7425-3629)	1	1,435	3,164	YU131655	35S22522A-3	312	884	64	83	183	4.5	48	107	32	7	812	1834	2.2		
MGA48"x120" (7425-3629)	1	1,414	3,117	YU131655	35S22522A-4	312	884	64	83	183	4.5	48	107	32	7	812	1834	2.2		
MGA48"x120" (7425-3629)	1	1,480	3,269	YU228928	35S23009A-4	277	855	64	77	145	4	47	112	28	4	821	1815	2.9		
MGA48"x120" (7425-5877)	1	1,437	3,188	YU229031	35S22903C-5	298	880	53	82	160	4.2	49	114	32	5	810	1813	1.7		
MGA48"x120" (7425-4403)	1	1,430	3,153	YU132680	35S23091B-11	281	837	56	80	154	4.4	50	113	30	5	801	1811	2.8		
MGA48"x120" (7427-3540)	1	1,430	3,153	YU132680	35S23091B-9	281	837	55	80	154	4.4	50	113	30	5	801	1811	2.8		
MGA48"x120" (7427-3540)	1	1,391	3,087	YU132680	35S23091B-12	281	837	55	80	154	4.4	50	113	30	5	801	1811	2.8		
MGA48"x120" (7427-3540)	1	1,395	3,080	YU228945	35S23007A-12	308	855	63	83	185	4.9	45	108	24	5	817	1824	3.1		
MGA48"x120" (7427-3540)	1	1,371	3,023	YU228945	35S23007A-13	308	855	63	83	185	4.9	45	108	24	5	817	1824	3.1		
MGA48"x120" (7427-3540)	1	1,375	3,031	YU228945	35S23007A-14	308	855	63	83	185	4.9	45	108	24	5	817	1824	3.1		
MGA48"x120" (7427-3540)	1	1,375	3,031	YU228945	35S23007A-15	308	855	63	83	185	4.9	45	108	24	5	817	1824	3.1		
MGA48"x120" (7427-3540)	1	1,423	3,137	YU132689	35S23083A-11	294	848	63	82	181	5.2	51	115	31	3	802	1823	2.8		
18 22.35 50.245																				
NO MERCURY CONTAMINATION																				
Send request for all Heat NO.																				
PRODUCT IN ACCORDANCE WITH A.S.M.E. A-100																				

NO MERCURY CONTAMINATION
 HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
 BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE

Product in accordance with ASTM A340, A480,
 A362S, ASTM A340, QQ369SD.

YEH MAU CORP.

Lin Kim Hing
 Manager of Quality Assurance Section

1694 304 4 S

1004 186, 184

